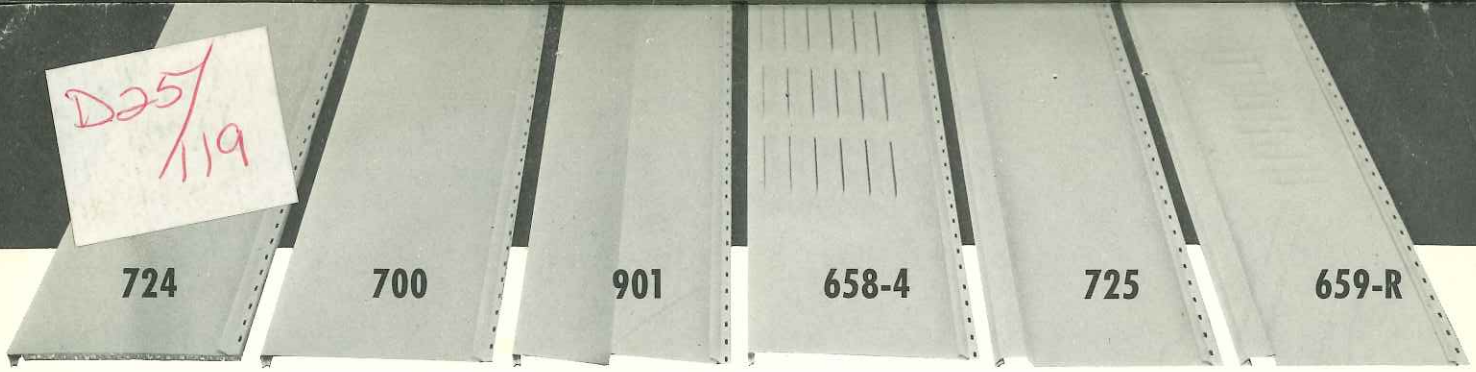
D25/119



724 — INSULATED SIDING. Horizontal 8″ x 12′6″ long. (Approved for direct stud application.)
700 — NON-INSULATED SIDING. Horizontal 8″ x 12′6″ long.
901 — DOUBLE FOUR SIDING. Horizontal, Non-Insulated 7½″ x 12′6″ long.
658-4 — HORIZONTAL LOUVERS. 8″ x 4 ft. long.
658-6 — HORIZONTAL LOUVERS. Same as 658-4 except 6 ft. long.
725 — VERTICAL SIDING. Non-Insulated, 8″ x 10′0″ long.
659-R — RIGHT VERTICAL LOUVERS. 8″ x 10′0″ long. When installed Batten appears on right side of louvers.
659-L — LEFT VERTICAL LOUVERS. Same as 659-R except when installed Batten appears on left side of louvers.

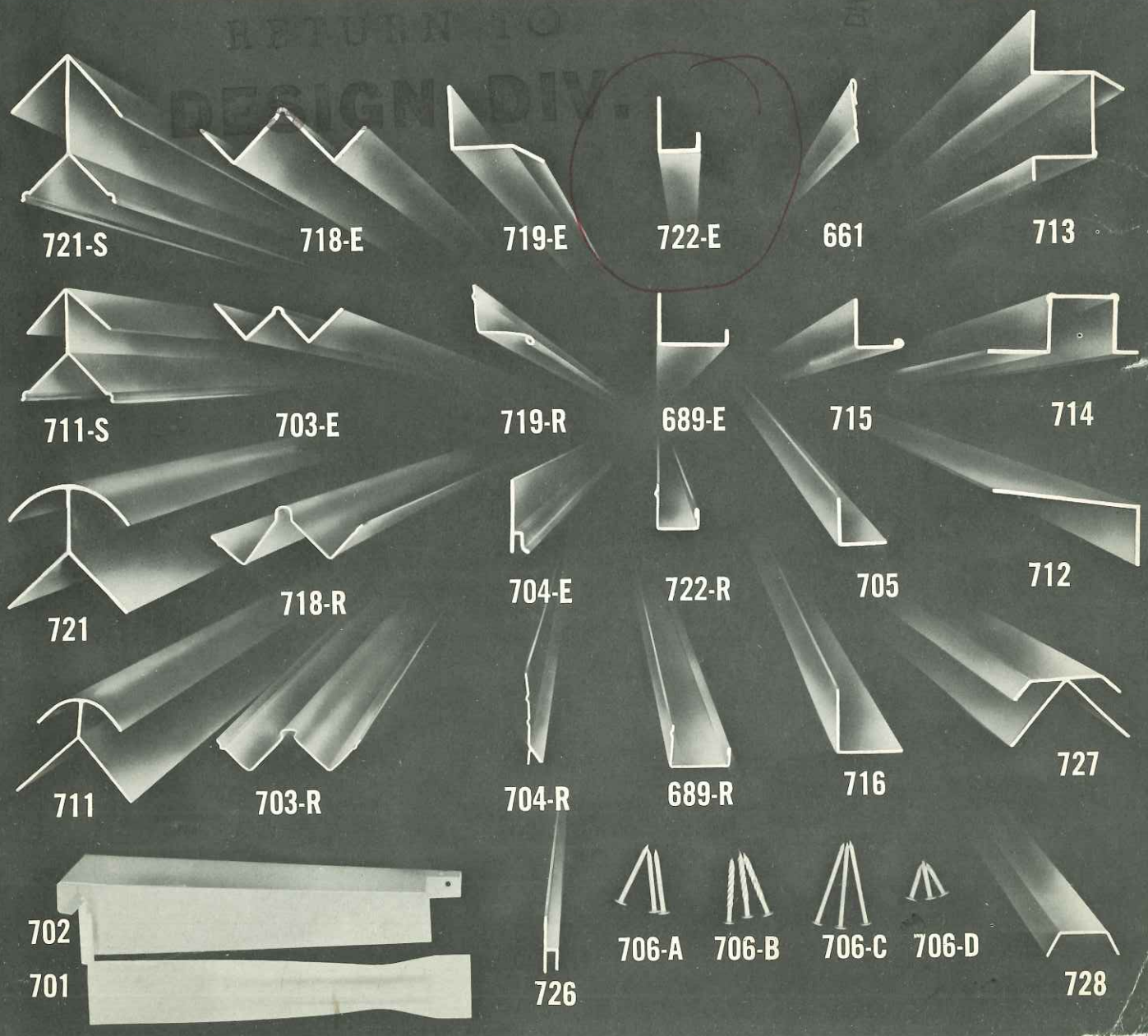
ALL SIDING MEETS F.H.A. SPECIFICATIONS

PATENT OFFICE
SEP 19 1961
DIVISIONS 81

HOW TO INSTALL ALUMINUM SIDING...

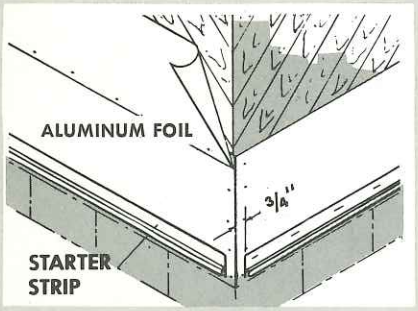
Pg. 1

RETURN TO DESIGN DIV.

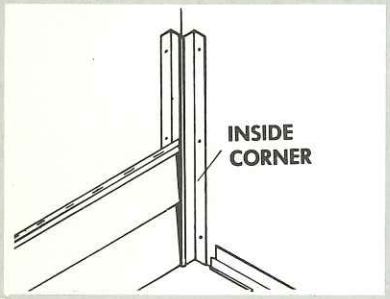


INSTALLATION OF NON-INSULATED HORIZONTAL SIDING

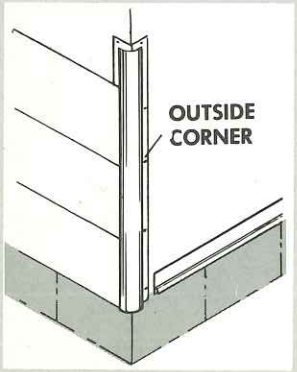
Inspect and plan job. Replace rotten boards and nail down loose boards and shingles. Furr out walls if necessary. Tools required: Rule, Level, Chalk line, Carpenter's square, Hammer, Caulking Gun, Hand Power Saw equipped with an Aluminum Cutting Blade 1/16" thick and 6 teeth per inch, Double Action Aviation Snips, Utility Knife, Metal File, Tin Snips, Fine Tooth Hacksaw, Carpenter's Saw and nail set. When installing siding DO NOT DRIVE NAILS TIGHT.—All nails must be firm but not tight as this will buckle the siding. Use aluminum nails only. For added insulation, apply aluminum foil first, using tacks or ½" staples.



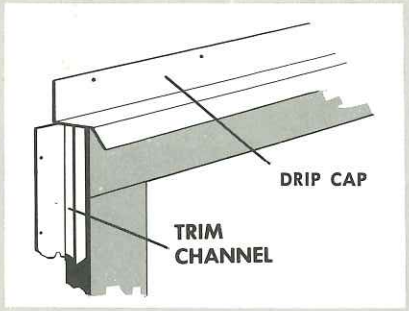
1 Using a chalk line and level, nail Starter Strip around bottom. Keep ¾" from corners.



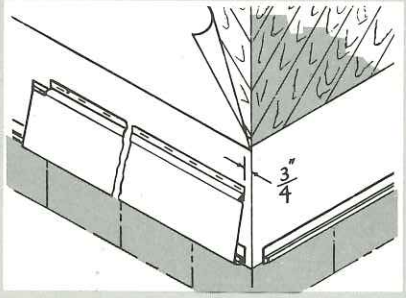
2 Before siding, nail Inside Corner strips into place. Siding later fits into grooves as shown.



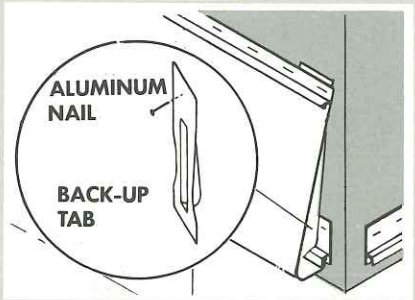
3 OPTIONAL—If continuous corner is used in place of corner caps, the continuous corner must be installed before siding.



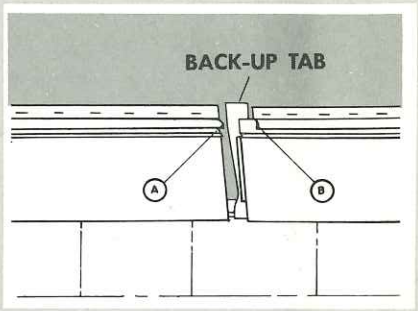
4 Nail Drip Caps across windows and doors. Nail Trim Channel on the sides.



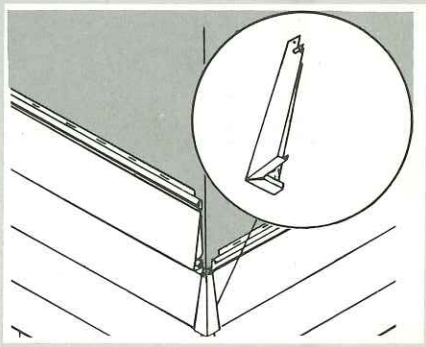
5 Seat first course of siding into Starter Strip. Keep siding panel ¾" from edges of corners. (¼" for insulated siding.)



6 Back-up Tab fits only one way—with flat side out. Nail through siding slots to secure panel and tab to house. Use tabs at joints, at ends of all panels, and at intermediate points. (Omit tabs on Double Four Siding.)



7 Lap panels (A butts against B) away from greatest traffic. For example, on the sides of home lap front panels over rear panels.

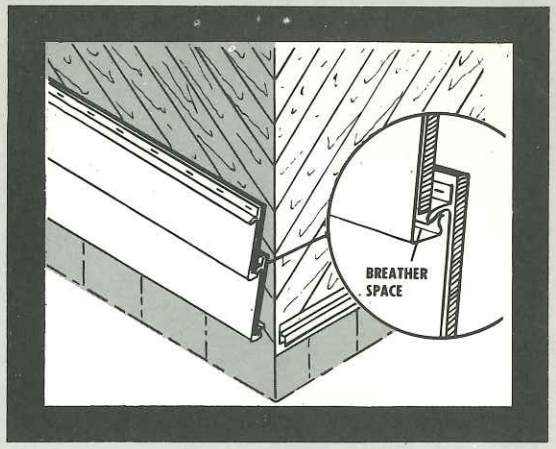


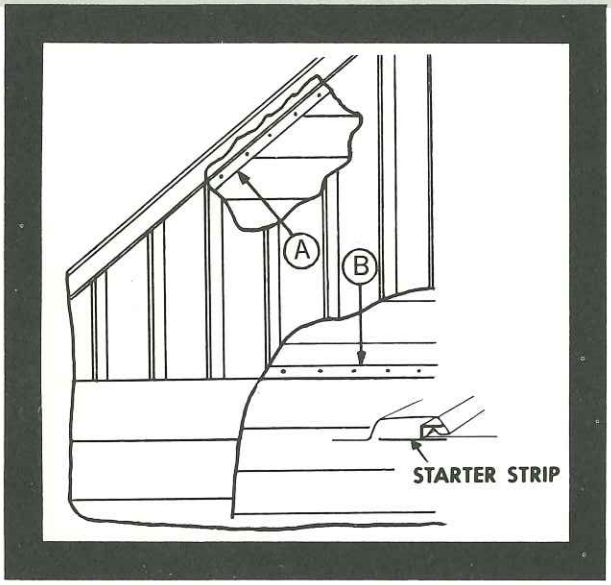
8 Attach Corner Caps as work progresses. Nail each corner securely through holes provided. (Substitute continuous corner on Double-Four siding)

9 Cut siding to fit around windows and doors. Use Undersill Trim to cover cut edges underneath windows and eaves, furring when necessary to maintain correct panel angle.

INSTALLATION OF INSULATED HORIZONTAL SIDING

Keep siding panels ¼" back from outside corners.
Nail ½" wood strip under starter strip to maintain proper panel angle.
Use 2" long nails.
Omit back-up tabs.
Use insulated trim. (See back cover.)
Remove enough foam insulation from cut portion of siding panels to fit into Undersill Trim.
Otherwise follow general instructions outlined for non-insulated siding.
NOTE: When using Drop-in Backerboard or Backerfoam align with top of siding panel to allow breather space as shown.





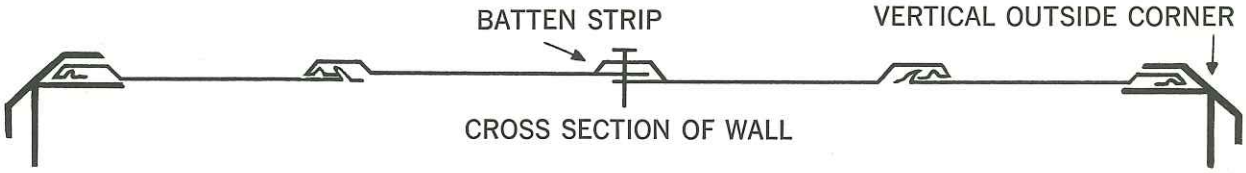
INSTALLATION OF VERTICAL SIDING

GABLES

Nail trim channel 722 at top of gables (A). Use trim angle 716 at base of vertical panels (B). Nail starter strip 726 on center line. Cut off batten from vertical siding panel. Place cut edge of siding panel in starter strip as shown. Apply siding panels to each side of center.

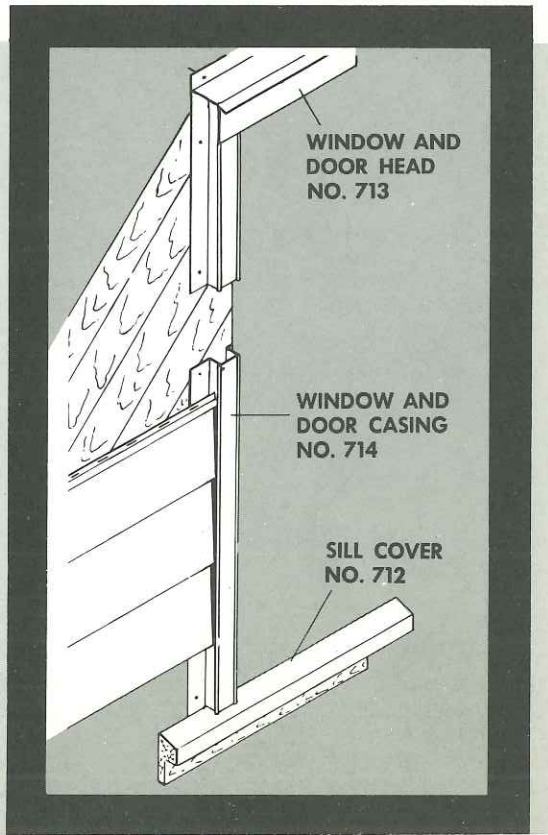
WALLS

Before siding, fasten outside corners 727. Use trim channel 722 at eave line and trim angle 716 at base. Apply siding from each end. Splice with batten strip as shown.



WINDOW AND DOOR CASING

Replace old casing with these extrusions. NOTE: Do not remove old sills if they are solid. Just cover with this sill cover. (See illustration)



GENERAL INFORMATION

Caulk where required.
On completion of job remove finger marks and soil.
One pound of aluminum nails is enough for approximately three squares of siding.
One box of back-up tabs (250) will do 3 squares of siding.
One box of corner caps (100) will cover 6 corners of a one story home.
All siding and trim available in the following colors:

Ivory	Beige	Gray
Brown	Rose	Yellow
White	Redwood	Pink
Green	Blue	Light Green

D 13/6

707 — ALUMINUM FOIL. 3 ft. wide, 500 Sq. Ft. per Roll.

710 — BACKERBOARD. 6 ft. long. Use with non-insulated Horizontal Siding.

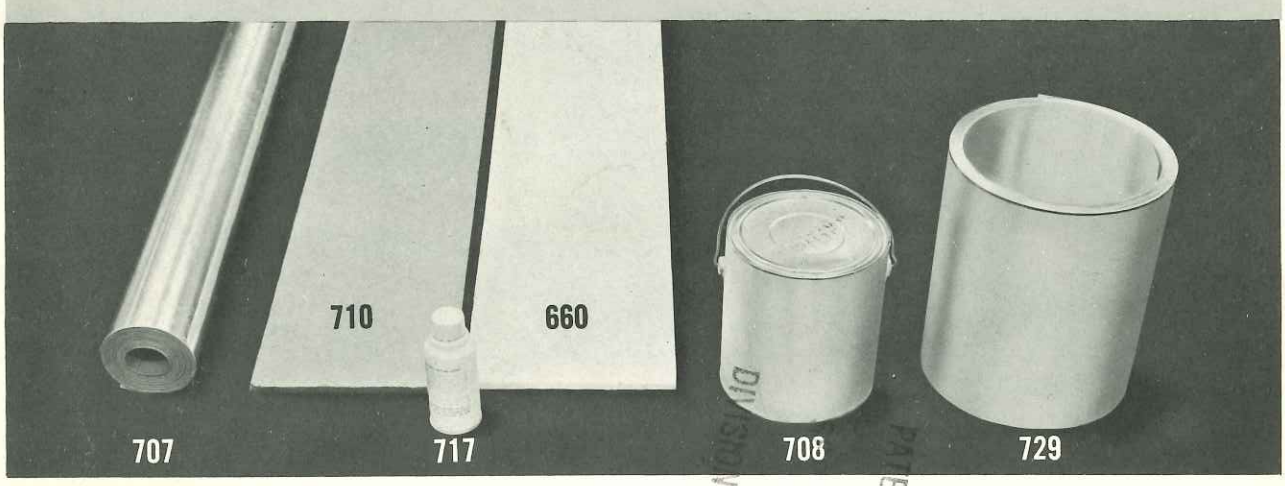
660 — BACKER FOAM. 6 ft. long. Use with non-insulated Horizontal Siding.

729 — FLAT COIL STOCK. 10 11/16" wide, 50 ft. per roll. Painted or bare.

708 — CAULKING COMPOUND. Gallon cans.

684 — CAULKING CARTRIDGES.

717 — TOUCH-UP PAINT. Spray Can, State Color.



PATENT OFFICE
DIVISIONS 81 & 82
1961

721-S — OUTSIDE CORNER. Extruded, Square Nose, For Insulated Siding. 10 ft. long.

711-S — OUTSIDE CORNER. Extruded, Square Nose, For Non-Insulated Siding, 10 ft. long.

721 — OUTSIDE CORNER. Extruded, Round Nose, For Insulated Siding. 10 ft. long.

711 — OUTSIDE CORNER. Extruded, Round Nose, For Non-Insulated Siding, 10 ft. long.

702 — CORNER CAP. Individual Corner for use on outside corners of Horizontal Siding.

701 — BACK-UP TAB. Use to reinforce Horizontal Siding.

718-E — INSIDE CORNER. Extruded, For Insulated Siding, 10 ft. long.

703-E — INSIDE CORNER. Extruded, For Non-Insulated Siding, 10 ft. long.

718-R — INSIDE CORNER. Rolled, For Insulated Siding, 10 ft. long.

703-R — INSIDE CORNER. Rolled, For Non-Insulated Siding, 10 ft. long.

719-E — DRIP CAP. Extruded, 12 ft. long.

719-R — DRIP CAP. Rolled, 12 ft. long.

704-E — STARTER STRIP. Horizontal, Extruded, 12 ft. long.

704-R — STARTER STRIP. Horizontal, Rolled, 10 ft. long.

726 — STARTER STRIP. Vertical, Extruded, 10 ft. long.

722-E — TRIM CHANNEL. For Non-Insulated Siding, Extruded, 12 ft. long.

689-E — TRIM CHANNEL. For Insulated Siding, Extruded, 12 ft. long.

722-R — TRIM CHANNEL. For Non-Insulated Siding, Rolled, 12 ft. long.

689-R — TRIM CHANNEL. For Insulated Siding, Rolled, 12 ft. long.

706-A — NAILS. Plain, 1½" long, Aluminum.

706-B — NAILS. Screw Type, 1½" long, Aluminum.

706-C — NAILS. Plain, 2" long, Aluminum.

706-D — NAILS. Plain, ¾" long, Aluminum.

661 — UNDERSILL TRIM. Rolled, 12 ft. long.

715 — BEADED TRIM. Extruded, 12 ft. long.

705 — ANGLE. 1" x 1" Extruded, 12 ft. long.

716 — ANGLE. 1⅜" x 1⅜" Extruded, 12 ft. long.

713 — WINDOW HEADER. Extruded, 12 ft. long.

714 — WINDOW CASING. Extruded, 12 ft. long.

712 — SILL COVER. Extruded, 12 ft. long.

727 — OUTSIDE CORNER. For Vertical Siding, Extruded, 10 ft. long.

728 — BATTEN STRIP. Extruded, 10 ft. long.

RETURN TO DESIGN DIV.

Manufactured by Keystone

KEYSTONE ALLOYS COMPANY, DERRY, PA.

Form No. G-875